

Work Order ID 136566

Thursday, September 03, 2015 8:02:42 AM

136566

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Item ID: D2747 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Set Screw
Start Date: 9/4/2015 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 9/4/2015 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: MCS Date: SEP 04 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2747	Rev B

100 PURCHASING 0.00
100
Purchasing Memo 0.00
Purchasing Issue P/O: 29720 3/8"-24 UNF SS Set Screw 7/8" to 1"
longPossible Supplie: McMaster CarrP/N:92311A639Material release note
required
CL SEP 08 2015 50

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
Packaging Memo 0.02
Packaging Ensure material release note is attached
50x SP15-09-11

120 QC6- Inspect dimensions to drawing 0.00
120
QC Memo 0.00
Quality Control
50 DAS
38
9-89
SEP 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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 Start Date: 9/4/2015 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 9/4/2015 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location STODA	0.00							
130									
Packaging	Memo	0.01				SOX	DAS	6	SEP 14 2015
Packaging							9.89		
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.08				MLS			SEP 15 2015
Quality Control									

SA 20150915

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

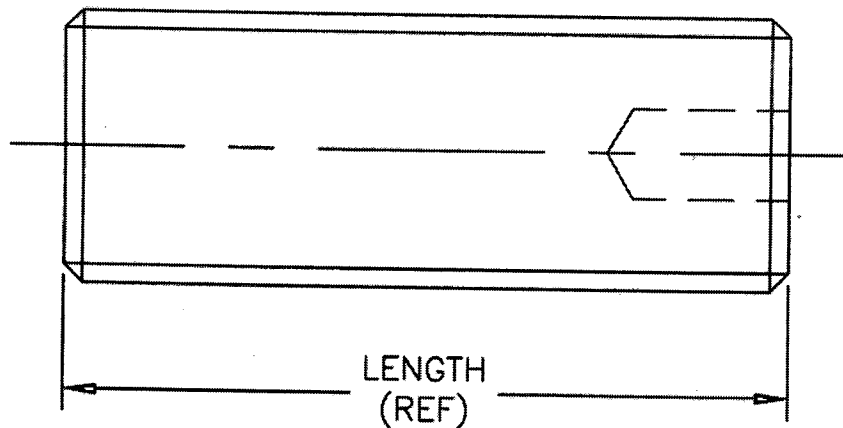
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			



DESIGN DS	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2747	REV. B SHEET 1 OF 1
DATE 05.03.09		TITLE SET SCREW	SCALE NTS
A	98.08.26	NEW ISSUE	
B	05.03.09	REDRAWN, STAINLESS STEEL ONLY	

RELEASED
05.08.09 *[Signature]*



D2747 SET SCREW

- 1) TYPE: HEX SOCKET HEAD SET SCREW
- 2) MATERIAL: STAINLESS STEEL
- 3) THREAD: 3/8"-24 UNF
- 4) LENGTH = 7/8" TO 1"
- 5) FINISH: NONE
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

136566 MJS
15-09-04

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29720**

Purchase Order Date 9/8/2015

PO Print Date 9/8/2015

Page Number 1 of 4

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	92311A564 AS PER DWG D3533 REV. B B136509	Set Screw	9/10/2015 Yes 9/10/2015		50.00 ✓ Each	\$0.23	\$11.65
Line Total:							\$11.65
2	95606A170 AS PER DWG D3631 REV. A B136593	Washer	9/10/2015 Yes 9/10/2015		100.00 ✓ Each	\$0.09	\$8.60
Line Total:							\$8.60
3	92311A639 AS PER DWG D2747 REV. B B136566	SS SET SCREW	9/10/2015 Yes 9/10/2015		50.00 ✓ Each	\$0.66	\$33.10

SP15-09-11

Note:

9/8/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO29720

Order Placed By
Chantal Lavoie

McMaster-Carr Number
8354615-01

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09/08/2015

Line	Product	Ordered	Shipped
1	92311A564 18-8 Stainless Steel Cup Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50	1 Pack	1
2	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1
3	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10	5 Packs	5
4	7049K24 UL Class RK5 Time-Delay Fuse, 600 VAC, 15 Amps, Fuse Types: FRS-R, TRS-R, FLS-R	4 Each	4
5	1325K54 Dow Corning Molykote 55 O-Ring Lubricant, 5.3-Ounce Tube	1 Each	1
6	91251A353 Black-Oxide Alloy Steel Socket Head Cap Screw, 10-32 Thread, 2" Length, Packs of 25	4 Packs	4
7	7630A43 Plastic Masking Tape for High Temperatures, 2" Width X 18 Yards Length	8 Rolls	8
8	7630A42 Plastic Masking Tape for High Temperatures, 1" Width X 18 Yards Length	8 Rolls	8
9	3931T1 Panel-Mount Equipment Circuit Breaker, Rocker, Single Pole, 240 VAC, 60 VDC, 20 Amps	2 Each	2
10	3931T6 Clear Plastic Cover for Rocker Style, Panel-Mount Equipment Circuit Breaker	2 Each	2

SP15-09-11